



TONGDA MACHINERY

Tongda Blow Moulding Machine TDW-1200L

<p>Specially design for IBC drum,Pallet and Water tank</p> <p>Tiebarless clamping design, 4 lock cylinders</p> <p>Clamping force up to 1200KN</p> <p>Mold platen size 1800*1600mm, open stroke 1100-2700mm</p> <p>Extruder screw diameter 150mm L/D=32:1, extruder motor 200KW with extruding capacity 550Kg/hr, diehead accumulator 45L</p>

Description.....

suitable material		HMW HDPE
capacity(Max) 1)	liters	1000 IBC drum
extruding motor power	Kw	200
dry cycle time	second	22
extruding capacity ¹⁾²⁾³⁾⁴⁾	Kg/hr	550
weight of machine	tons	50

Extruder.....

screw diameter	mm	150
screw L/D		32
screw material		38CrMnAIA
screw treatment		nitrogen treatment
screw hardness		HV≥800
barrel material		38CrMnAIA
barrel treatment		nitrogen treatment
barrel hardness		HV≥900
driving method		inverter control, Inverter Mitsubishi
driving power	Kw	200
rotate speed	rpm	10~50
plastisizing capacity ¹⁾²⁾³⁾⁴⁾	Kg/hr	550
temperature controlling method		PLC module for temperature controlling AI-casting heating ring with insulating layer and stainless steel cover
heating method		
temperature control prcision		±0.5%

heating Power	Kw	58
heating zones		6
cooling for barrel		6blowers
blower power	w	
diehead adjustment	-	forward and backward adjustable
extruder cover adjustment	-	up and down adjustable
barrel with feeding groove		Yes
saftey closure		Yes

Accumulator diehead.....

structure		FIFO vertical structure, easy to change color
runner		rotate runner , overcome weld line of parision, decrease internal stress of the part.
accumulator volume	liters	45
heating method		stainless steel heating band
heating power	Kw	60
heating zones		8
material		38CrMoAIA,42CrMoV,35CrMo
internal treatment		inner mirror
temperature controlling		controlling
die diameter scope	mm	300-720

Clamping unit.....

rodless claming model, linear guider for clamping unit close and open, LOW FRICTION FORCE, HIGH SPEED, HIGH PRECISION AND ANTI-wearing		
clamping force	KN	1300
mold plate size (w*h)	mm	1800*1600
platen distance	mm	1100-2700
max. Mould dimension(w*h)	mm	1200*2300
clamping position checking		Electronic ruler
safety protection		FOTEK LIGHT-ELECTRONIC SAFE DEVICE WITH SIX SECTIONS

Parison thickness controlling unit.....

manufacturer		Moog Japan
servo vavle		Moog Japan
driving power	Kw	11KW, with hydraulic accumulator
controller points		100
control stroke	mm	50

Hydraulic system

proportional controlling system with YUKEN or VIECKERS, low noise, energy saved, high speed, stable and long life;		
working pressure		140
pump maker		Denison or Sunny
vavle maker		YUKEN
oil pump motor	kw	75
oil temperature alarm		available. P.I.D ALARMING FUNCTION WHEN OIL

Control system.....

This machine is available for large plastics container , of designed optimizely , of fully automatically, of high speed and integrated by mechanic and electric and hydraulic.		
This system uses PLC from MITSUBISHI Japan, with human-machine interface control from HITECH Taiwan		
other parts		Fuji,Omron,scherider
thermo couple		k

Blow unit-Optional.....

simple below blowing for pallet		
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Utilities.....

power resource	three phrases and four lines,380V/50HZ	
total connected load	Kw	390
average consumption	Kw	280
air pressure	kg/cm2	8
air flow	m3/min	4
cold water	m3/h	20
cold water temperature	°C	5~10°C

overall dimension.....

length	mm	10600
width	mm	3500
height	mm	5600

- 1) depends on the mold and product
- 2) depends on raw material
- 3) approximate value
- 4) depends on process condition

Our company has right to revise the above technical data. No notify when revising.